

Date: Monday, 2/19/2007 8:07:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 30750	
Estimate Number : 12736	
P.O. Number : <u>N/A</u>	Part Number : D353515
This Issue : 2/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3535 UNDER REVIEW ^{Rev A.} 07.02.19
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL/MED FAB	Drawing Revision : U/R
Previous Run : <u>N/A</u>	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 2/26/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature] 07.02.19</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: M10193

SAD 07/02/25

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

SAD 07/02/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07.02.25

12

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D3535 using Jig DT8158
 3-Identify as D3535-15

SB MF 07-03-06 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30750

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07/03/07 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/07 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: EP

07/03/08

07/03/08 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08 (12)

Job Completion



07/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

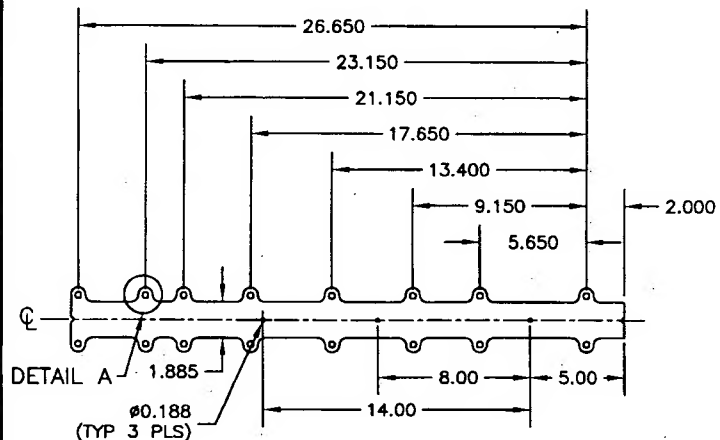
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

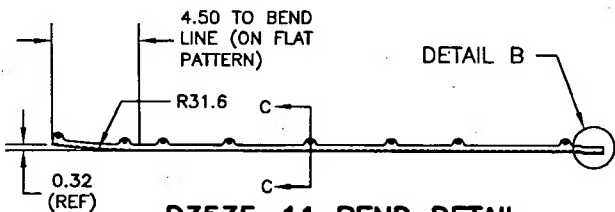
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07.02.12

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3535	REV. A
		TITLE	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE		SCALE 1:10



D3535-11F FLAT PATTERN

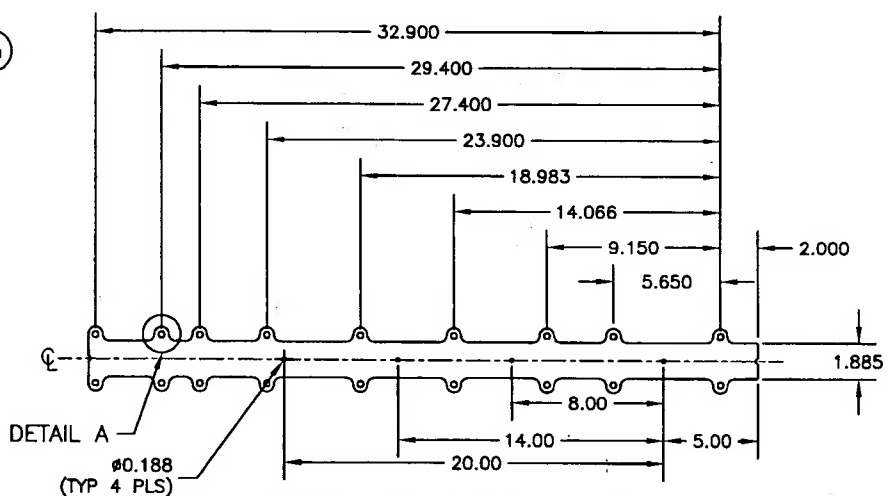


D3535-11 BEND DETAIL

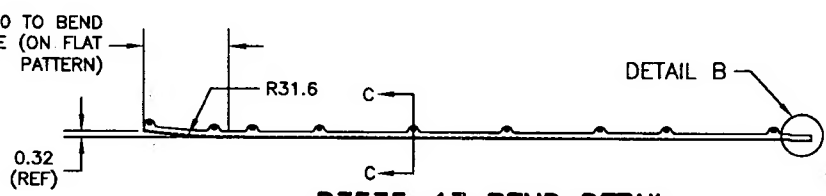
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

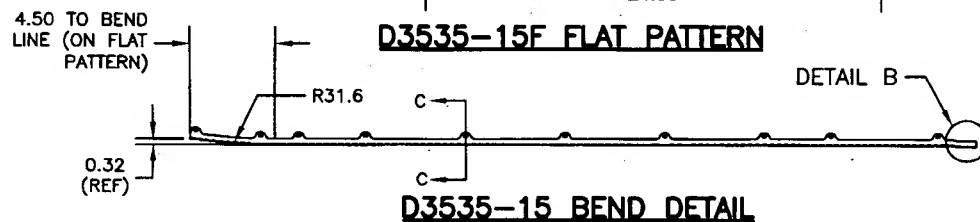
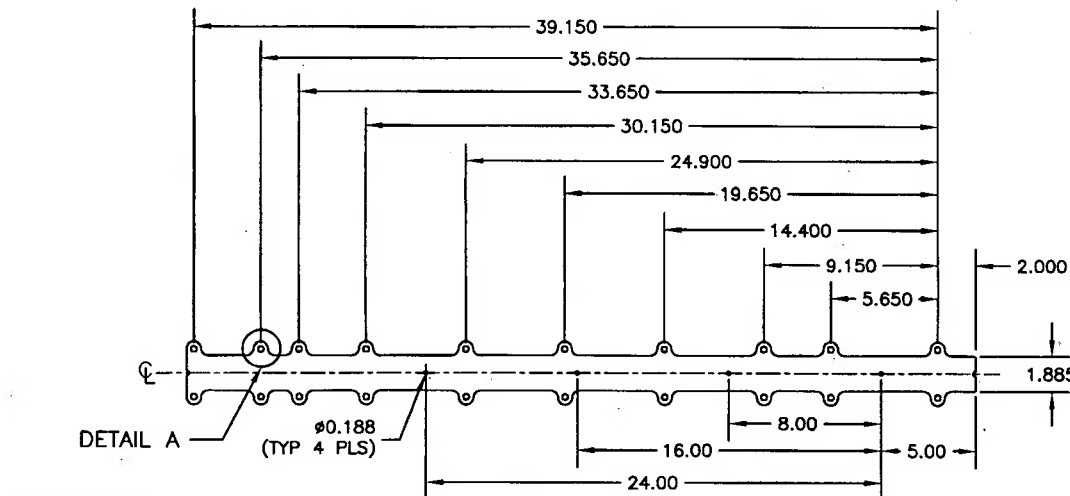
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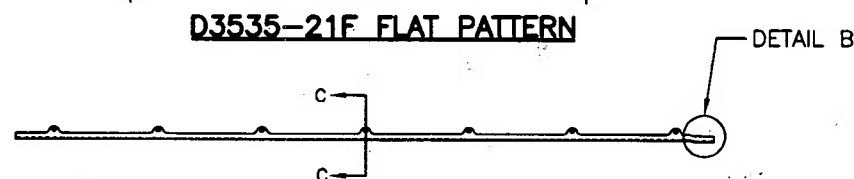
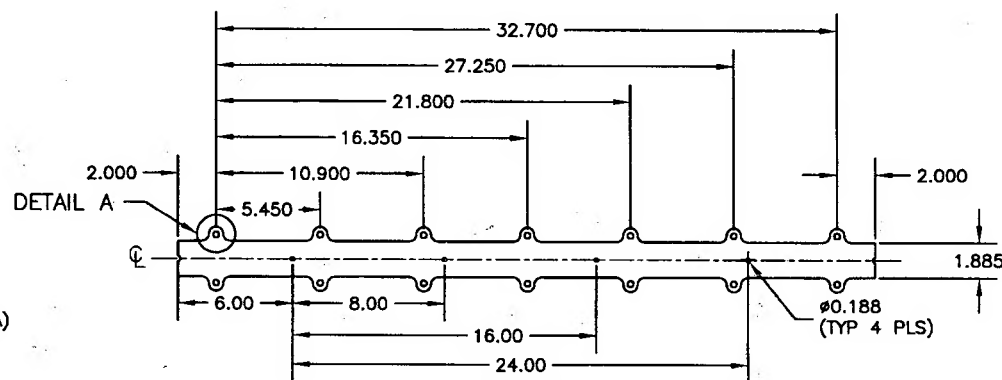
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DATE	06.10.25	TITLE	D3535	WEARSHOE
				REV. A
				SHEET 2 OF 7
				SCALE
				1:10

07.02.12
#



D3535-15F FLAT PATTERN

D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN

D3535-21 BEND DETAIL

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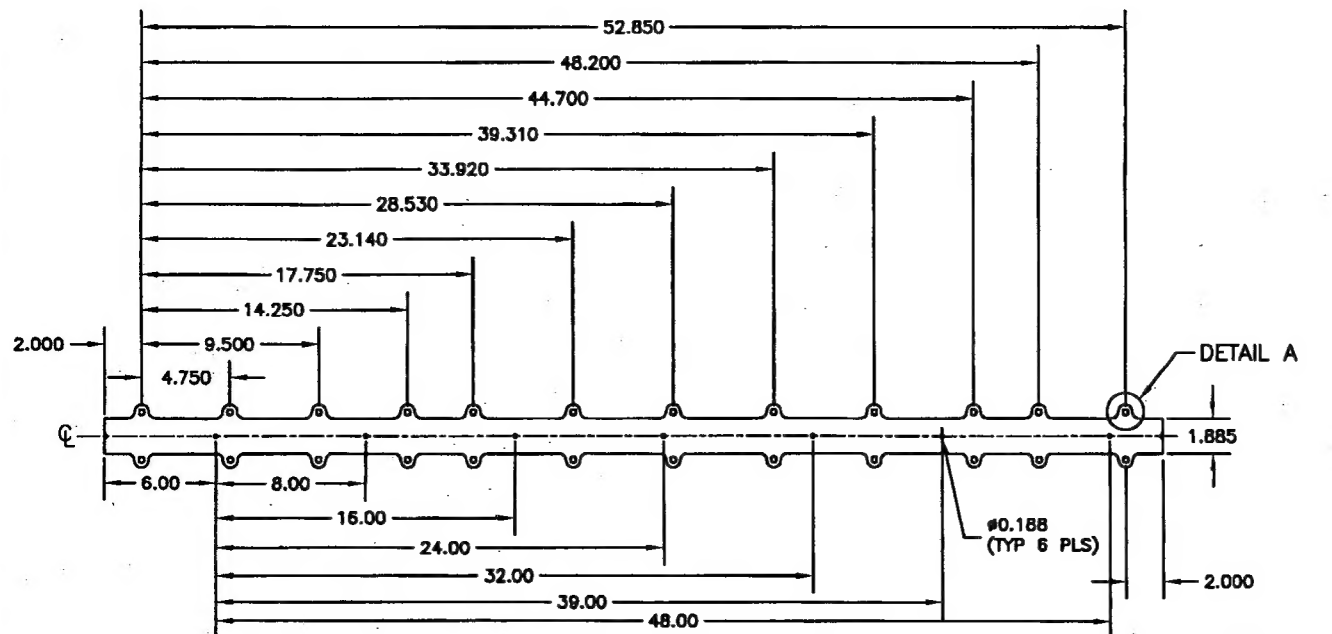
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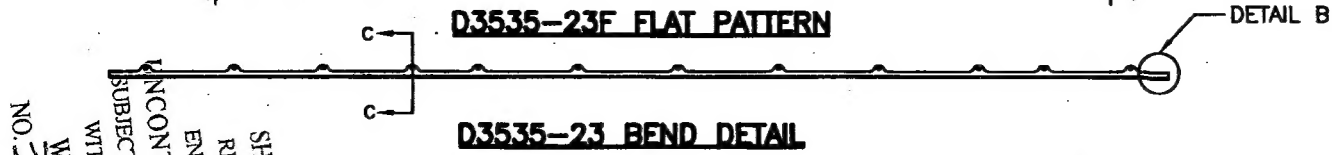
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CHECKED AM	APPROVED AM	DRAWING NO. D3535	SHEET 3 OF 7
DATE 06.10.25	TITLE WEARSHOE	SCALE 1:10	

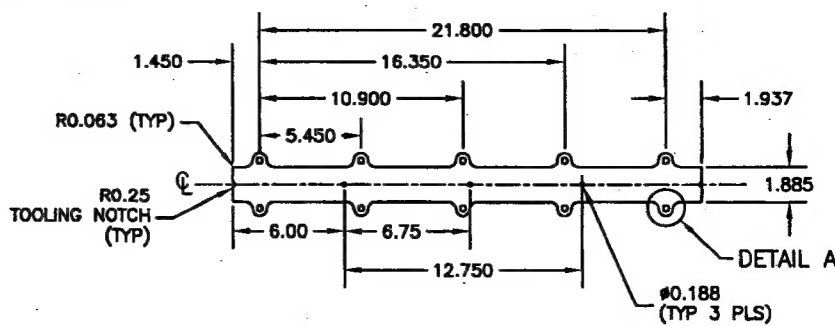
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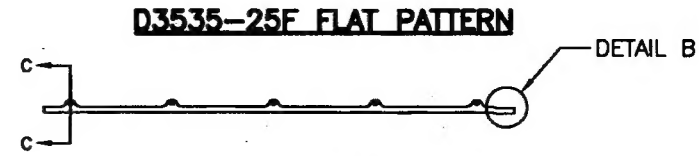
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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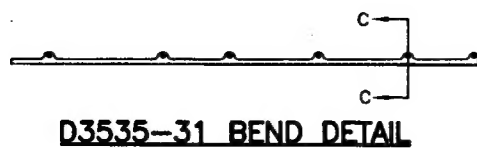
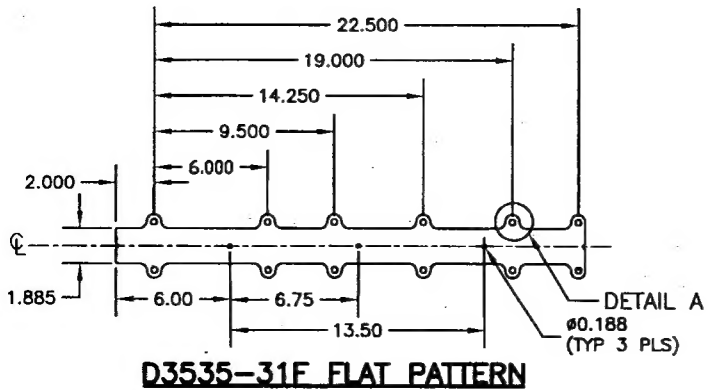
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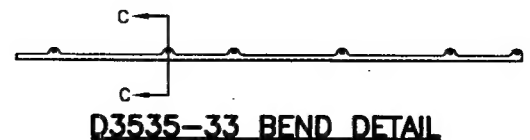
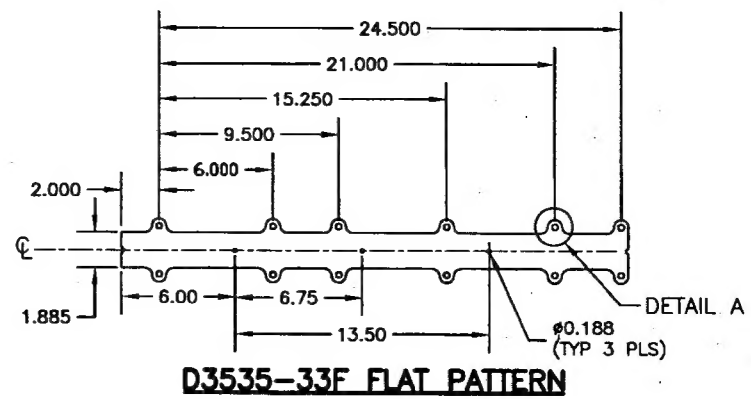
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DATE	06.10.25	TITLE	D3535	WEARSHOE
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07.02.12 CH



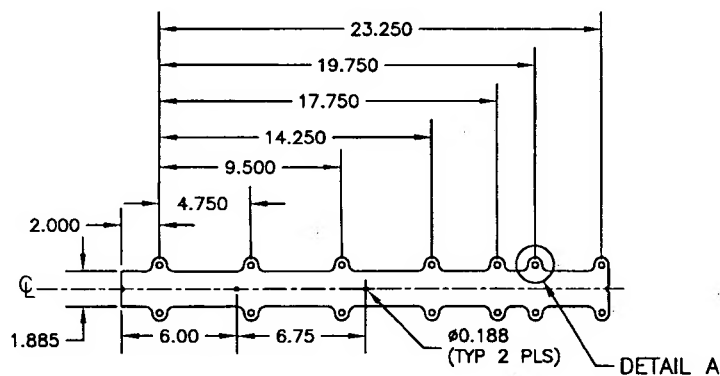
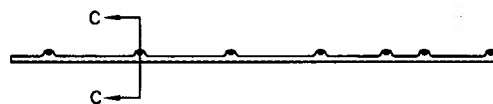
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- NOTES**
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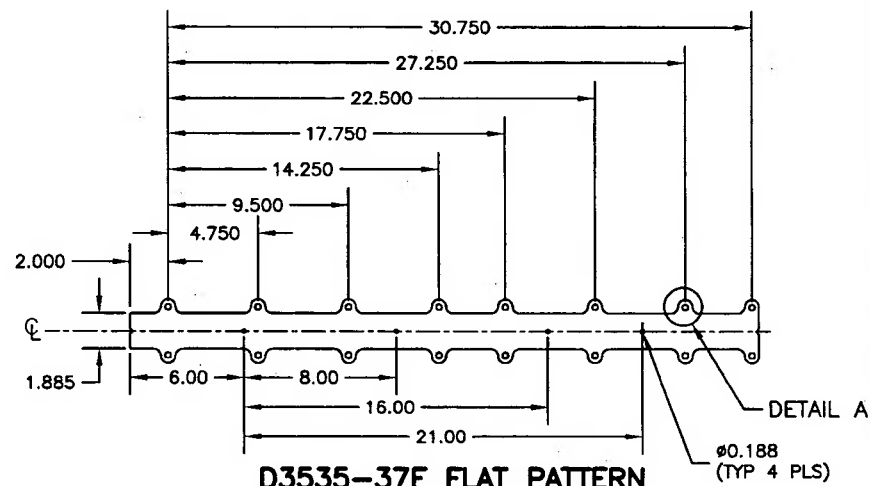
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CB	CB	PORT HADLOCK, WA	
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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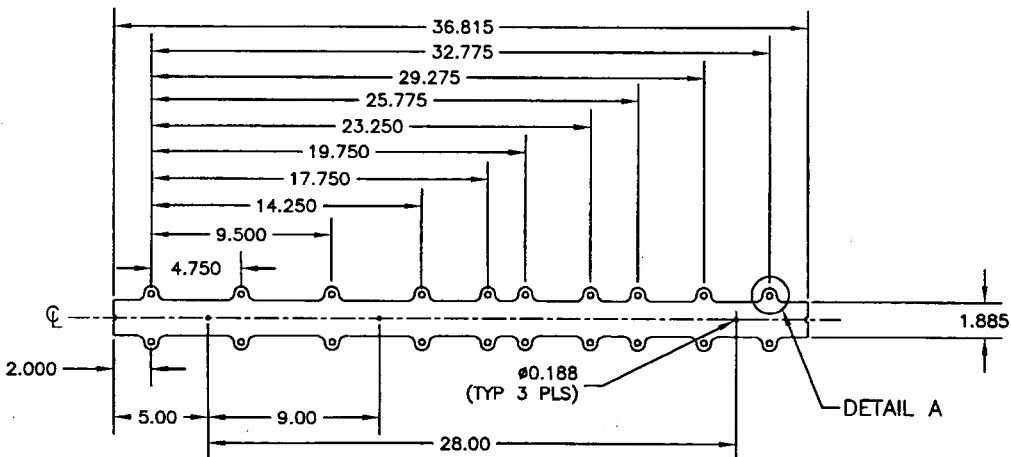
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

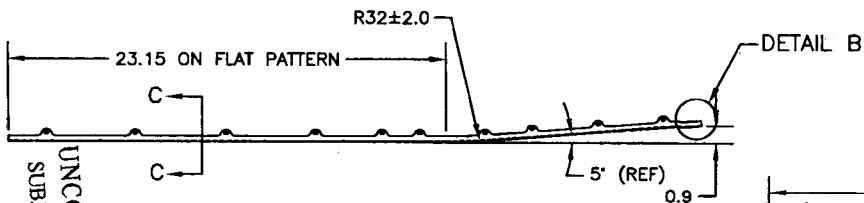
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DATE	06.10.25	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET	6 OF 7	
		REV.	A	

07.02.12



D3535-39F FLAT PATTERN

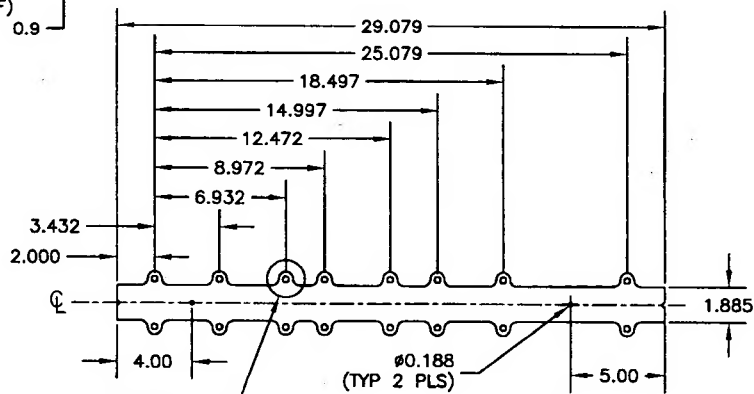


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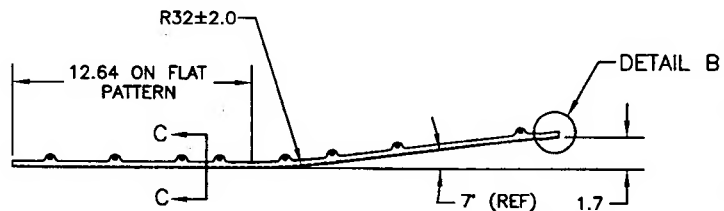
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D3535-41F FLAT PATTERN

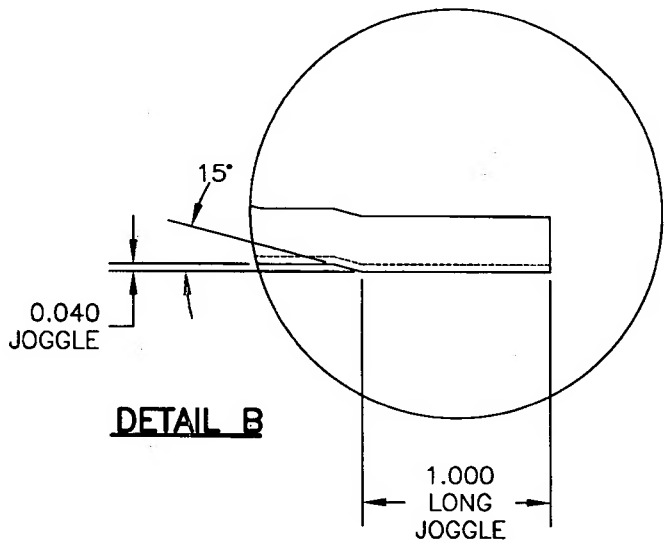


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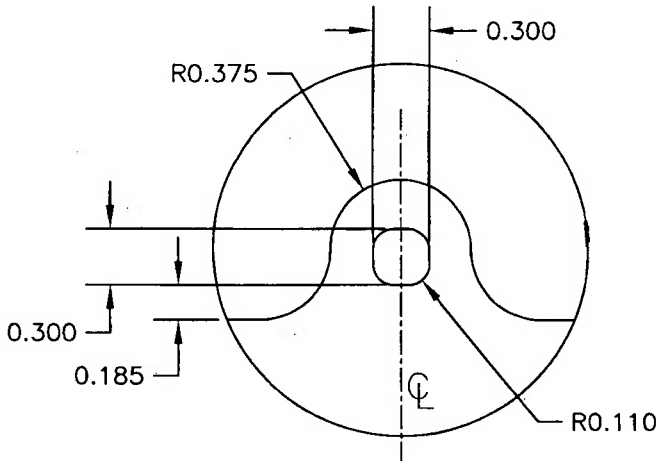


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DATE	06.10.25	DRAWING NO.	D35.35	REV. A
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

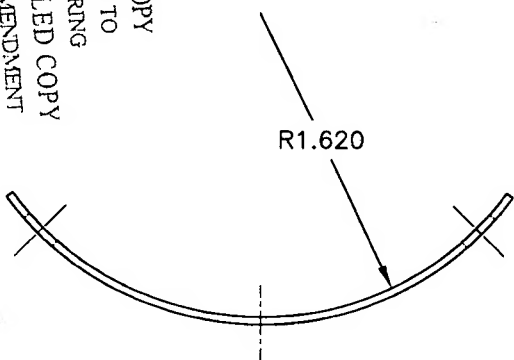
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DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER
NO. 30750

DART AEROSPACE LTD		Work Order: 30750
Description:		Part Number: D3525-15
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	± 0.010	39.150	✓		M-T	
35.650	± 0.010	35.650	✓		M-T	
33.650	± 0.010	33.650	✓		M-T	
30.150	± 0.010	30.150	✓		M-T	
24.900	± 0.010	24.900	✓		M-T	
19.650	± 0.010	19.650	✓		M-T	
14.400	± 0.010	14.400	✓		M-T	
9.150	± 0.010	9.148	✓		Vern	
5.650	± 0.010	5.648	✓		Vern	
2.000	± 0.010	2.001	✓		Vern	
1.885	± 0.010	1.888	✓		Vern	
5.00	± 0.030	5.00	✓		Vern	
8.10	± 0.030	7.996	✓		Vern	
16.10	± 0.030	16.01	✓		Vern	
24.00	± 0.030	24.01	✓		Vern	
0.188	± 0.001	0.188	✓		Vern	
0.300	± 0.010	0.297	✓		Vern	
0.300	± 0.010	0.299	✓		Vern	
0.038	± 0.010	0.038	✓		Vern	

Measured by: SAJ	Audited by: BC	Prototype Approval:
Date: 07/02/25	Date: 07.02.25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	